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Department of  
Agriculture

Food Safety  
and Inspection  
Service

HACCP-3

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Pt.3

# Generic HACCP\* Model for Poultry Slaughter

\*Hazard Analysis  
and Critical Control  
Point (HACCP)

Poultry Slaughter  
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POULTRY Slaughter





# Introduction

## HACCP Generic Model for Poultry Slaughter

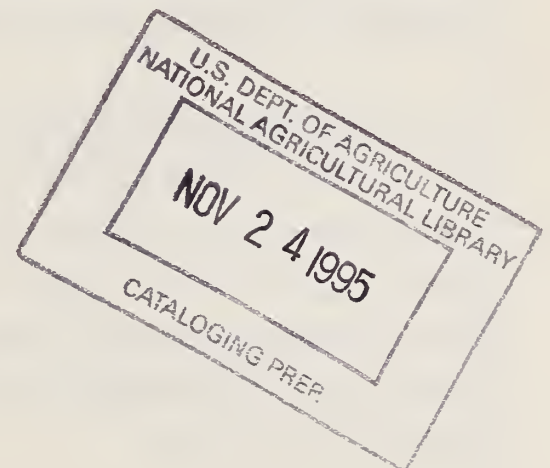
Hazard Analysis and Critical Control Points (HACCP) is a system of process control. It is designed to prevent the occurrence of problems by ensuring that controls are applied at any point in a food production system where hazardous or critical situations could occur. Hazards could include microbiological, chemical, or physical adulteration of food products.

In late May 1993, U.S. Department of Agriculture (USDA) Secretary Mike Espy directed USDA's Food Safety and Inspection Service (FSIS) to provide him with a plan for implementing mandatory HACCP in the nation's meat and poultry establishments. The Secretary recognized that such a system, which has been under study by FSIS, was a necessary building block of the inspection system of the future.

In workshops held in 1991 and 1992, five generic HACCP models were developed and are being published for public information. The models should be useful for companies developing individualized plans.

The five generic HACCP models are:

- Refrigerated Foods
- Cooked Sausage
- Poultry Slaughter
- Fresh Ground Beef
- Swine Slaughter



The workshop for Poultry Slaughter was held in Atlanta, Georgia, from August 27-29, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for poultry slaughter, including: receiving, scalding, venting/opening/eviscerating, offline procedures, neck and giblet chilling, final wash, carcass chilling, packaging/labeling, and storage/distribution. This is the generic HACCP model for Poultry Slaughter.

Information on the other four workshops follows:

The workshop for Fresh Ground Beef was held in Phoenix, Arizona, from December 3-5, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for fresh ground beef, including: sanitation, receiving, storage, assembly/pre-weigh/pre-grind (re-work), final grind, packaging/labeling, storage, and shipping. This is the generic HACCP model for Fresh Ground Beef.

The workshop for Pork Slaughter (Market Hogs) was held in Minneapolis, Minnesota, from March 31-April 2, 1992. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for pork slaughter, including: receiving/holding, scalding, dehairing, trimming, neck breaker/head dropping/brisket opening, splitting, trim rail/final rail inspection for trimming, cooler, operational sanitation, and pre-op sanitation. This is the generic HACCP model for Pork Slaughter (Market Hogs).

The workshop for Cooked Sausage was held in Fort Worth, Texas, from May 21-23, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 9 critical control points (CCP's) for cooked sausage, including: receiving, meat preparation, non-meat ingredient compounding, pre-blend/formulation/staging (re-work), cooking/smoking, chilling/storage, peeling, packaging, and storage. This is the generic HACCP model for Cooked Sausage.

The workshop for Refrigerated Foods was held in Baltimore, Maryland, from February 26-28, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 14 critical control points (CCP's) for refrigerated foods, including: preparation, cooking, chilling, assembling components into packages, flushing with gas atmosphere, package inspection, labeling and code dating, chilling, and storage. This is the generic HACCP model for Refrigerated Foods.



## PRODUCT CATEGORY DESCRIPTION

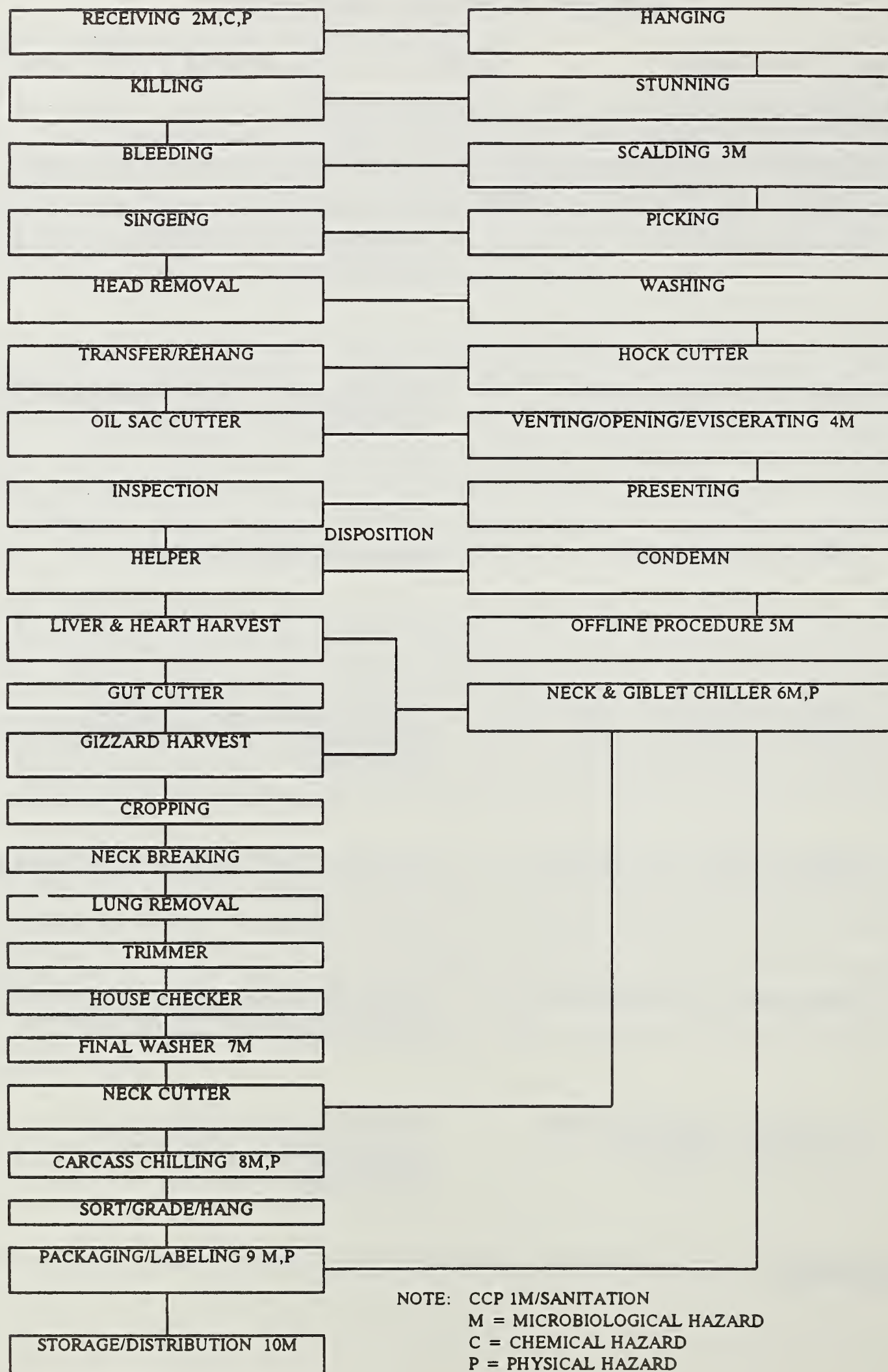
**PRODUCT CATEGORY : READY TO COOK WHOLE YOUNG CHICKEN**

**WORKSHOP LOCATION : ATLANTA, GA**

**THE FOLLOWING QUESTIONS NEED TO BE ANSWERED WHEN DEVELOPING THE PRODUCT CATEGORY DESCRIPTION:**

- |  |   |
|--|---|
| <b>1. COMMON NAME?</b>                               | <b>READY TO COOK WHOLE YOUNG CHICKEN</b>                          |
| <b>2. HOW IS IT TO BE USED?</b>                      | <b>FOR HUMAN CONSUMPTION AFTER COOKING</b>                        |
| <b>3. TYPE OF PACKAGE?</b>                           | <b>BAG, BOXED AND BULK</b>  |
| <b>4. LENGTH OF SHELF LIFE, AT WHAT TEMPERATURE?</b> | <b>VARIES WITH METHOD OF PACKAGING AND TEMPERATURE OF STORAGE</b> |
| <b>5. WHERE WILL IT BE SOLD?</b>                     | <b>RETAIL, WHOLESALE AND OTHER</b>                                |
| <b>6. LABELING INSTRUCTIONS?</b>                     | <b>KEEP REFRIGERATED OR FROZEN; COOK PRIOR TO CONSUMPTION</b>     |
| <b>7. IS SPECIAL DISTRIBUTION CONTROL NEEDED?</b>    | <b>VARIES WITH METHOD OF PACKAGING AND TEMPERATURE OF STORAGE</b> |

## DESCRIPTION





**LIST PRODUCT CATEGORIES AND INGREDIENTS**

**PRODUCT CATEGORY : READY TO COOK WHOLE YOUNG CHICKEN**

**WORKSHOP LOCATION : ATLANTA, GA**

**MEAT**

**CHILLED RTC YOUNG CHICKENS**

**LIVE YOUNG CHICKENS**

**CATEGORY**

**INDUSTRY HACCP WORKSHOP  
FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT**

**PRODUCT CATEGORY** : **READY TO COOK WHOLE YOUNG CHICKEN**

**WORKSHOP LOCATION** : **ATLANTA, GA**  
**PRODUCT HAZARD** : **MICROBIOLOGICAL**

HAZARD CHARACTERISTICS ASSOCIATED WITH THE FINISHED PRODUCT AND ITS INGREDIENTS. "+ " = A HAZARD EXISTS "0" = NO HAZARD EXISTS	HAZARD CHARACTERISTICS						R I S K
	A	B	C	D	F	F	
(1) FINISHED PRODUCT (RTC WHOLE YOUNG CHICKENS)	*	+	+	+	+	0	IV
(2) INGREDIENT							
LIVE YOUNG CHICKENS	*	+	+	+	+	+	V

\*HAZARD CHARACTERISTIC "A" N/A for industry generic workshop HACCP model.

**NOTE:**

1. When doing Finished Product hazard analysis risk assignment, consider all ingredients and processes used in the establishment to produce the Finished Product.
2. When doing hazard analysis and risk assignment on ingredients, consider only those processes taking place prior to product arriving at the receiving dock of the consuming establishment.



**INDUSTRY HACCP WORKSHOP  
FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT**

**PRODUCT CATEGORY** : **READY TO COOK WHOLE YOUNG CHICKEN**

**WORKSHOP LOCATION** : **ATLANTA, GA**

**PRODUCT HAZARD** : **CHEMICAL**

HAZARD CHARACTERISTICS ASSOCIATED WITH THE FINISHED PRODUCT AND ITS INGREDIENTS. "+" = A HAZARD EXISTS "0" = NO HAZARD EXISTS	HAZARD CHARACTERISTICS						R I S K
	A	B	C	D	E	E	
(1) FINISHED PRODUCT (RTC WHOLE YOUNG CHICKENS)	*	0	0	0	0	+	I
(2) INGREDIENT							
LIVE YOUNG CHICKENS	*	0	0	0	0	+	I

\*HAZARD CHARACTERISTIC "A" N/A for industry generic workshop HACCP model.

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**INDUSTRY HACCP WORKSHOP  
FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT**

**PRODUCT CATEGORY** : **READY TO COOK WHOLE YOUNG CHICKEN**

**WORKSHOP LOCATION** : **ATLANTA, GA**

**PRODUCT HAZARD** : **PHYSICAL**

HAZARD CHARACTERISTICS ASSOCIATED WITH THE FINISHED PRODUCT AND ITS INGREDIENTS. "+" = A HAZARD EXISTS "0" = NO HAZARD EXISTS	HAZARD CHARACTERISTICS						R I S K
	A	B	C	D	E	E	
(1) FINISHED PRODUCT (RTC WHOLE YOUNG CHICKENS)	*	0	0	+	0	0	I
(2) INGREDIENT							
LIVE YOUNG CHICKENS	*	0	0	0	0	0	0

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**NOTE:**

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# INDUSTRY WORKSHOP HACCP MODEL

## (SUBMITTED BY STEERING COMMITTEE 10/25/91)

**PRODUCT CATEGORY: WHOLE YOUNG CHICKENS**  
**LOCATION: ATLANTA, GA**

A	B	C	D	E	F	G	H
PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
SANITATION	CCP 1M	CCP 1M PRE-OP	CCP 1M VISUALLY CLEAN (ORGANOLEPTIC)	CCP 1M CONDUCT PRE-OPERATIVE INSPECTION OF MEAT HANDLING EQUIPMENT AND IMMEDIATE ENVIRONMENT ACCORDING TO PLANT PROCEDURE (I.E., VISUAL AND ORGANOLEPTIC).	CCP 1M REWASH, SANITIZE, REINSPECT PRIOR TO OPERATION. REVIEW DEVIATION WITH SANITATION PERSONNEL.	CCP 1M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 1M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. TARGET VALUE OF 100 CFU PER SQUARE INCH IF SWABBING. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
RECEIVING WATER & ICE	CCP 2M	CCP 2M POTABILITY	CCP 2M STATE PUBLIC HEALTH STANDARDS.	CCP 2M MEET GUIDELINES FOR POTABILITY.  REQUIRE POTABILITY CERTIFICATE FOR OUTSIDE PURCHASED ICE.  MONITOR INCOMING CHLORINE IF CITY WATER OR CONDUCT TESTING TO MEET CITY OR STATE REQUIREMENTS.	CCP 2M RESAMPLE FOR VERIFICATION OF FIRST TEST. CHLORINATE, IF APPLICABLE. CHANGE SOURCE OF SUPPLY IF POSSIBLE.	CCP 2M CERTIFICATE ON RECORD AND/OR LAB REPORT.	CCP 2M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
	CCP 2P	CCP 2P FOREIGN MATERIAL	CCP 2P NONE DETECTED.	CCP 2P MEET TEST ON A SUFFICIENT BASIS TO ASSESS THE QUALITY OF EACH LOT.	CCP 2P CONTROL PRODUCT FOR DISPOSITION. EVALUATE ICE HANDLING EQUIPMENT FOR POSSIBLE CAUSE OF DEVIATION AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 2P RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 2P AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.



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**PRODUCT CATEGORY: WHOLE YOUNG CHICKENS**  
**LOCATION: ATLANTA, GA**

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PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
PACKAGING/ NON-MEAT SUPPLIES	CCP 2C	CCP 2C FOOD GRADE MATERIALS	CCP 2C MUST BE FOOD GRADE MATERIALS.	CCP 2C CONTINUING LETTER OF GUARANTEE.	CCP 2C CONTROL SUPPLIES FOR DISPOSITION. CONTACT SUPPLIER FOR DOCUMENTATION PRIOR TO USE.	CCP 2C LETTER OF GUARANTEE ON FILE AND/OR PLANT SPECIFIC LOG/RECORD.	CCP 2C AUDIT TO VERIFY ACCURACY OF LETTERS AGAINST CURRENT MATERIALS USAGE. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
SCALDING	CCP 3M	CCP 3M FRESH WATER INPUT	CCP 3M WATER INPUT TO ACHIEVE A MINIMUM OF 1 QUART PER BIRD.	CCP 3M MONITOR FLOW RATE TO MAINTAIN AN INPUT OF 1 FRESH QT. PER BIRD AT MAXIMUM LINE SPEED.	CCP 3M IMMEDIATELY ADJUST FRESH WATER FLOW. RECHECK WITHIN 15 MINUTES. RECHECK EVERY HOUR UNTIL 4 CONSECUTIVE CHECKS DOCUMENT COMPLIANCE.	CCP 3M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 3M AUDIT TO VERIFY CALIBRATION OF METERING DEVICES AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
VENTING/ OPENING/ Eviscerating	CCP 4M	CCP 4M ANY VISUAL DIGESTIVE CONTENT CONTAMINATION	CCP 4M MACHINE ADJUSTED TO CONTROL CONTAMINATION (% DETERMINED BY EQUIPMENT, PLANT HISTORY, ETC.).	CCP 4M INITIAL EVALUATION OF EACH FLOCK; THEREAFTER, EVERY TWO HOURS MINIMUM, BASED ON FLOCK CHARACTERISTICS TO CONTROL WITHIN ESTABLISHED STANDARDS.	CCP 4M IMMEDIATELY ADJUST EQUIPMENT. EVALUATE OPERATION FOR CAUSE OF ERROR AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 4M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 4M AUDIT BY VISUAL OBSERVATION TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 4M CHLORINATION	CCP 4M ≥ 20 PPM AT THE SPRAY NOZZLES (AS PER USDA REGULATIONS).	CCP 4M TIMELY OPERATIONAL MONITORING TO ENSURE ≥ 20 PPM AT POINT OF CONTACT	CCP 4M IMMEDIATELY ADJUST CHLORINATION. RECHECK WITHIN 15 MINUTES. EVALUATE CHLORINE SYSTEM FOR CAUSE AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 4M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 4M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF RAPID METHODS USING STANDARDIZED AOAC OR EQUIVALENT METHODS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.

\* LOG/RECORD RETAINED FOR AN APPROPRIATE PERIOD OF TIME. RESULTS RECORDED AT CCP SITE ON A REAL TIME BASIS.



# INDUSTRY WORKSHOP HACCP MODEL

## (SUBMITTED BY STEERING COMMITTEE 10/25/91)

**PRODUCT CATEGORY: WHOLE YOUNG CHICKENS**  
**LOCATION: ATLANTA, GA**

A	B	C	D	E	F	G	H
PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
OFFLINE PROCEDURES	CCP 5M	CCP 5M FOREIGN AND EXTRANEIOUS MATERIAL; CONTAMINATION.	CCP 5M FOLLOWS PLANT APPROVED OFFLINE PROCEDURES.	CCP 5M MONITOR TO ENSURE PROPER TECHNIQUE IS USED AND RECORD RESULTS.	CCP 5M CONTROL PRODUCT FOR DISPOSITION. EVALUATE PROCEDURES FOR CAUSE OF DEVIATION AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 5M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 5M AUDIT BY VISUAL OBSERVATION TO VERIFY PROCEDURE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
NECK & GIBLET CHILLING	CCP 6M	CCP 6M TEMPERATURE	CCP 6M SUFFICIENT TO MEET USDA REQUIREMENTS FOR GIBLETS AND NECKS.	CCP 6M MEASURE WATER TEMPERATURE AT EXIT WITH A CONTINUOUS RECORDER AT EXIT OR A MINIMUM OF ONCE PER HOUR AT EXIT. MONITOR PRODUCT TEMPERATURE ONCE PER HOUR.	CCP 6M CONTROL PRODUCT FOR DISPOSITION. IMMEDIATELY ADJUST WATER TEMPERATURE. EVALUATE CHILLING PROCEDURE FOR CAUSE OF DEVIATION AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 6M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 6M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF TEMPERATURE DEVICES WITH CALIBRATED DEVICE. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 6M FRESH WATER INPUT	CCP 6M SUFFICIENT TO MEET USDA REQUIREMENTS FOR GIBLETS AND NECKS.	CCP 6M MAINTAIN FLOW RATE PER MOISTURE PROCEDURES	CCP 6M IMMEDIATELY ADJUST FRESH WATER FLOW. RECHECK WITHIN 15 MINUTES.	CCP 6M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 6M AUDIT TO VERIFY CALIBRATION OF METERING DEVICES AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 6M CHLORINATION	CCP 6M CHLORINATED AT AN EFFECTIVE LEVEL.	CCP 6M TIMELY OPERATIONAL MONITORING AT INPUT SUFFICIENT TO MAINTAIN EFFECTIVE LEVEL (TO BE DETERMINED BY PILOT STUDY).	CCP 6M IMMEDIATELY ADJUST CHLORINATION. RECHECK WITHIN 15 MINUTES. EVALUATE CHLORINE SYSTEM FOR CAUSE AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 6M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 6M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF RAPID METHODS USING STANDARDIZED AOAC OR EQUIVALENT METHODS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.

# INDUSTRY WORKSHOP HACCP MODEL

## (SUBMITTED BY STEERING COMMITTEE 10/25/91)

**PRODUCT CATEGORY: WHOLE YOUNG CHICKENS**  
**LOCATION: ATLANTA, GA**

A	B	C	D	E	F	G	H
PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
	CCP 6P	CCP 6P FOREIGN MATERIAL	CCP 6P VISUALLY FREE OF HAZARDOUS FOREIGN MATERIAL.	CCP 6P HOURLY VISUAL INSPECTION	CCP 6P CONTROL PRODUCT FOR DISPOSITION. IDENTIFY CONTAMINANT FOR POSSIBLE SOURCE. TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE	CCP 6P RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 6P AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
FINAL WASHER	CCP 7M	CCP 7M CHLORINATION	CCP 7M MINIMUM 20 PPM AVAILABLE CHLORINE (UNITED STATES).	CCP 7M TIMELY OPERATIONAL MONITORING TO ENSURE ≥ 20 PPM AT OUTPUT STATION.	CCP 7M IMMEDIATELY ADJUST CHLORINATION. RECHECK WITHIN 15 MINUTES. EVALUATE CHLORINE SYSTEM FOR CAUSE AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 7M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 7M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF RAPID METHODS USING STANDARDIZED AOAC OR EQUIVALENT METHODS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 7M WATER VOLUME AND DIRECTION	CCP 7M SUFFICIENT VOLUME PRESSURE, EQUIPMENT OPERATION, AND DWELL TIME TO REMOVE VISUAL CONTAMINATION ON INTERNAL AND EXTERNAL SURFACES.	CCP 7M VISUAL EXAMINATION OF AN APPROPRIATE NUMBER OF RANDOMLY SELECTED BIRDS TO MONITOR WASHER EFFICACY. DONE IN A TIMELY MANNER TO ASSURE EQUIPMENT OPERATES AT SPECIFIED PRESSURE, VOLUME AND DIRECTION	CCP 7M IMMEDIATELY ADJUST WATER FLOW AND DIRECTION. RECHECK WITHIN 15 MINUTES	CCP 7M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 7M AUDIT BY VISUAL OBSERVATION TO VERIFY ADEQUACY OF WATER, SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.



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**LOCATION: ATLANTA, GA**

A	B	C	D	E	F	G	H
PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS ★ SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
CARCASS CHILLING	CCP 8M	CCP 8M TEMPERATURE	CCP 8M SUFFICIENT TO MEET USDA REQUIREMENTS FOR CARCASS.	CCP 8M MONITOR EXIT TEMPERATURE OF BIRDS HOURLY.  CONTINUOUS MEASUREMENT BY RECORDING CHART AT CHILLERS WARMEST POINT.	CCP 8M CONTROL PRODUCT FOR DISPOSITION. IMMEDIATELY ADJUST WATER TEMPERATURE. EVALUATE CHILLING PROCEDURE FOR CAUSE OF DEVIATION AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 8M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 8M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF TEMPERATURE DEVICES WITH CALIBRATED DEVICE. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 8M FRESH WATER INPUT	CCP 8M SUFFICIENT TO MEET USDA REQUIREMENTS FOR CARCASS.	CCP 8M HOURLY CHECKS TO ASSURE FLOW RATE AS PER MOISTURE PROCEDURES	CCP 8M IMMEDIATELY ADJUST FRESH WATER FLOW. RECHECK WITHIN 15 MINUTES	CCP 8M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 8M AUDIT TO VERIFY CALIBRATION OF METERING DEVICES AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 8M CHLORINATION	CCP 8M CHLORINATION AT AN EFFECTIVE LEVEL.	CCP 8M TIMELY OPERATIONAL MONITORING WITH RAPID METHODOLOGY SUFFICIENT TO MAINTAIN AN EFFECTIVE LEVEL OF CHLORINE AT THE POINT OF INPUT (EFFECTIVE LEVEL TO BE DETERMINED BY PILOT STUDY).	CCP 8M IMMEDIATELY ADJUST CHLORINATION. RECHECK WITHIN 15 MINUTES. EVALUATE CHLORINE SYSTEM FOR CAUSE AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 8M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 8M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF RAPID METHODS USING STANDARDIZED AOAC OR EQUIVALENT METHODS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
	CCP 8P	CCP 8P FOREIGN MATERIAL	CCP 8P VISUALLY FREE OF HAZARDOUS FOREIGN MATERIAL.	CCP 8P HOURLY VISUAL INSPECTION.	CCP 8P CONTROL PRODUCT FOR DISPOSITION. IDENTIFY CONTAMINANT FOR POSSIBLE SOURCE. TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 8P RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 8P AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.

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PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
PACKAGING/ LABELING	CCP 9M	CCP 9M PRODUCT TEMPERATURE	CCP 9M WITHIN USDA REGULATIONS.	CCP 9M PRODUCT TEMPERATURE MEASURED EVERY HOUR.	CCP 9M CONTROL PRODUCT FOR DISPOSITION. IMMEDIATELY ADJUST COOLING/HANDLING PROCEDURE. EVALUATE PROCESS FOR CAUSE OF DEVIATION AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 9M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 9M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF TEMPERATURE DEVICES WITH CALIBRATED DEVICES. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 9M PACKAGING MATERIAL INTEGRITY	CCP 9M VISUALLY INTACT.	CCP 9M TIMELY MONITORING BY PRODUCTION	CCP 9M CONTROL PRODUCT FOR DISPOSITION. EVALUATE PACKAGING PROCEDURES FOR POSSIBLE CAUSE OF PROBLEM AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE	CCP 9M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD	CCP 9M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 9M HANDLING PRACTICES	CCP 9M USDA REGULATIONS FOR PACKAGING AREA.  NO OBSERVED PILEUPS.	CCP 9M CONTINUOUS RECORDING OF ROOM TEMPERATURE OR TIMELY MONITORING BY PRODUCTION.  MONITOR FOR PILEUPS AND CORRECT IMMEDIATELY.	CCP 9M IMMEDIATELY ADJUST ROOM TEMPERATURE AND CORRECT PRODUCT FLOW. EVALUATE FACILITIES AND PROCEDURES FOR CORRECTION TO PREVENT REOCCURRENCE.	CCP 9M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 9M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.

\* LOG/RECORD RETAINED FOR AN APPROPRIATE PERIOD OF TIME. RESULTS RECORDED AT CCP SITE ON A REAL TIME BASIS.

# INDUSTRY WORKSHOP HACCP MODEL

## (SUBMITTED BY STEERING COMMITTEE 10/25/91)

**PRODUCT CATEGORY: WHOLE YOUNG CHICKENS**  
**LOCATION: ATLANTA, GA**

A	B	C	D	E	F	G	H
PROCESS STEP	CCP HAZARD NUMBER	CCP DESCRIPTION	CRITICAL LIMITS	ESTABLISHMENT MONITORING	CORRECTIVE/ PREVENTIVE ACTION	HACCP RECORDS * SEE FOOTNOTE	HACCP SYSTEM VERIFICATION
	CCP 9P	CCP 9P FOREIGN MATERIAL	CCP 9P NO VISUAL CONTAMINATION.	CCP 9P TIMELY VISUAL INSPECTION BY PRODUCTION PERSONNEL.	CCP 9P CONTROL PRODUCT FOR DISPOSITION. IDENTIFY CONTAMINANT FOR POSSIBLE SOURCE. TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 9P RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 9P AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
STORAGE	CCP 10M	CCP 10M TEMPERATURE	CCP 10M ACCEPTABLE TEMPERATURE.	CCP 10M CONTINUOUS RECORDING OF ROOM TEMPERATURE OR TIMELY MONITORING BY PRODUCTION.	CCP 10M IMMEDIATELY ADJUST ROOM TEMPERATURE. EVALUATE FACILITIES AND PROCEDURES FOR CORRECTION TO PREVENT REOCCURRENCE.	CCP 10M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 10M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. VERIFY ACCURACY OF TEMPERATURE DEVICES WITH CALIBRATED DEVICES. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.
		CCP 10M PACKAGE INTEGRITY	CCP 10M VISUALLY INTACT.	CCP 10M TIMELY MONITORING BY PRODUCTION PERSONNEL.	CCP 10M CONTROL PRODUCT FOR DISPOSITION. EVALUATE STORAGE AND HANDLING PROCEDURES FOR POSSIBLE CAUSE OF PROBLEM AND TAKE CORRECTIVE ACTION TO PREVENT REOCCURRENCE.	CCP 10M RECORD ALL RESULTS AND CORRECTIVE ACTION(S) IN A PLANT SPECIFIC LOG/RECORD.	CCP 10M AUDIT TO VERIFY SAMPLING TECHNIQUE AND ACCURACY OF RECORDS. FREQUENCY AS NEEDED TO VALIDATE PLANT PROGRAM. DOCUMENT RESULTS.

\* LOG/RECORD RETAINED FOR AN APPROPRIATE PERIOD OF TIME. RESULTS RECORDED AT CCP SITE ON A REAL TIME BASIS.



**HACCP STEERING COMMITTEE  
(WHOLE YOUNG CHICKENS)**

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